

December-22-11 2:45:10 PM

Item ID: D3560-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: • Arm Weldment

Start Date: 22/12/2011 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 4.00 * 1 *

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/22 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng /- Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77933

77933

Page 2

December-22-11 2:45:10 PM

Item ID: D3560-042 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Arm Weldment
 Start Date: 22/12/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check

0.00

SL

12-01-17

130

QC

Memo

0.00

Quality Control

140

0.00

140

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch (65 deg C)

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

Alum. Rod. batch M 119712

2 0
 12-01-19

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77933

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N900040100

Setup Start ***NS1***

Stop *NS2*

4

4

Reference:

Run Start *NR1*

Stop ***NR2***

**Insp.
Stamp**

150

8120170

②

—۷۴۸

160

0.00

x 2

⑦

BF 12-01-20

170

0.00

2

LR 12-1-24.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Press bushing in D3560 arm per dwg D3562								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

2X PM 12/20/12

12/21/12

5/26/12

12

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/11/30 *[Signature]*
 MF
 12-01-20

W/O:		WORK ORDER CHANGES					
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Picklist Print

December-22-11 2:45:14 PM

Page 1

Work Order ID: 77933

77933

Parent Item: D3560-042

D3560-042

Parent Item Name: Arm Weldment

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.05.24 EC
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808

Manufactured

No

100

Each

22.0000

1

4

D2808

Bushing

**

Location

Loc Qty

Loc Code

GA

22

32896

2

71879

8

76188

12

M6061T6B0.500X05.00
0

Purchased

No

140

f

38.4750

1.395

5.873684

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

**

Location

Loc Qty

Loc Code

MAT001

38.475

112154

6.935

117933

7.54

119324

24

D3592-1

Manufactured

No

190

Each

9.0000

1

4

D3592-1

Plate

**

Location

Loc Qty

Loc Code

WA002

9

47015

2

48517

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

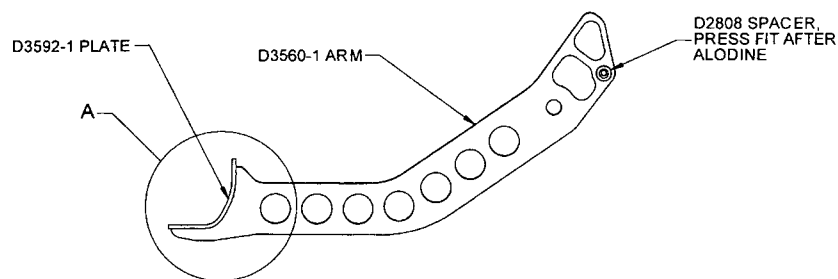
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

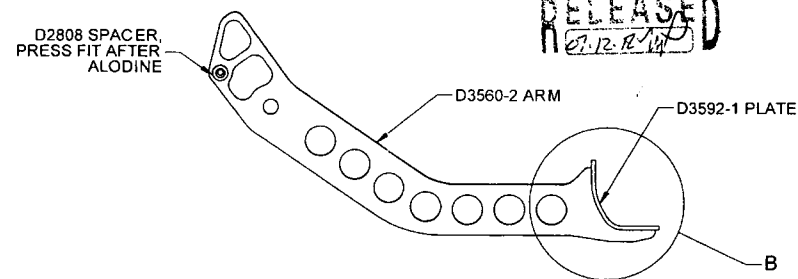
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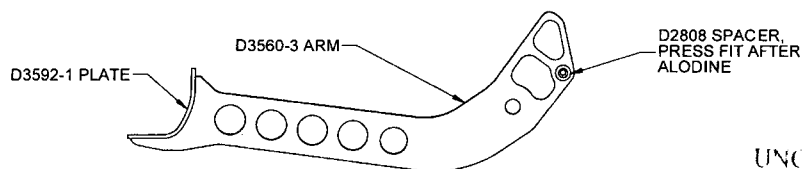
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07.12.16



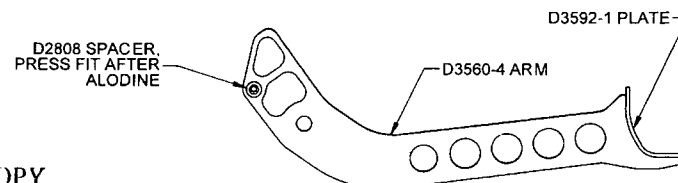
D3560-041 ARM WELDMENT



D3560-042 ARM WELDMENT

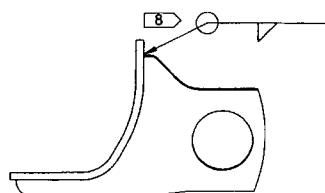


D3560-043 ARM WELDMENT

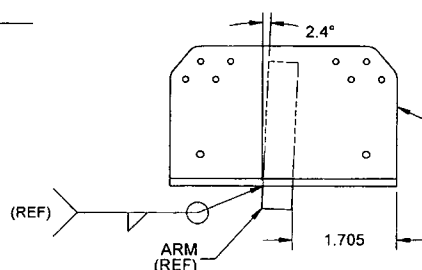


D3560-044 ARM WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77933 M.L.5
11/12/22



**DETAIL A
SCALE 1:2**



**DETAIL B
SCALE 1:2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.23 lbs (TYP)
8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN	100		
DRAWN	100		
CHECKED	100		
MFG. APPR.	100		
APPROVED	100		
DE APPR.	100		
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D
TITLE **ARM WELDMENT** SCALE 1:4
SHEET 1 OF 5

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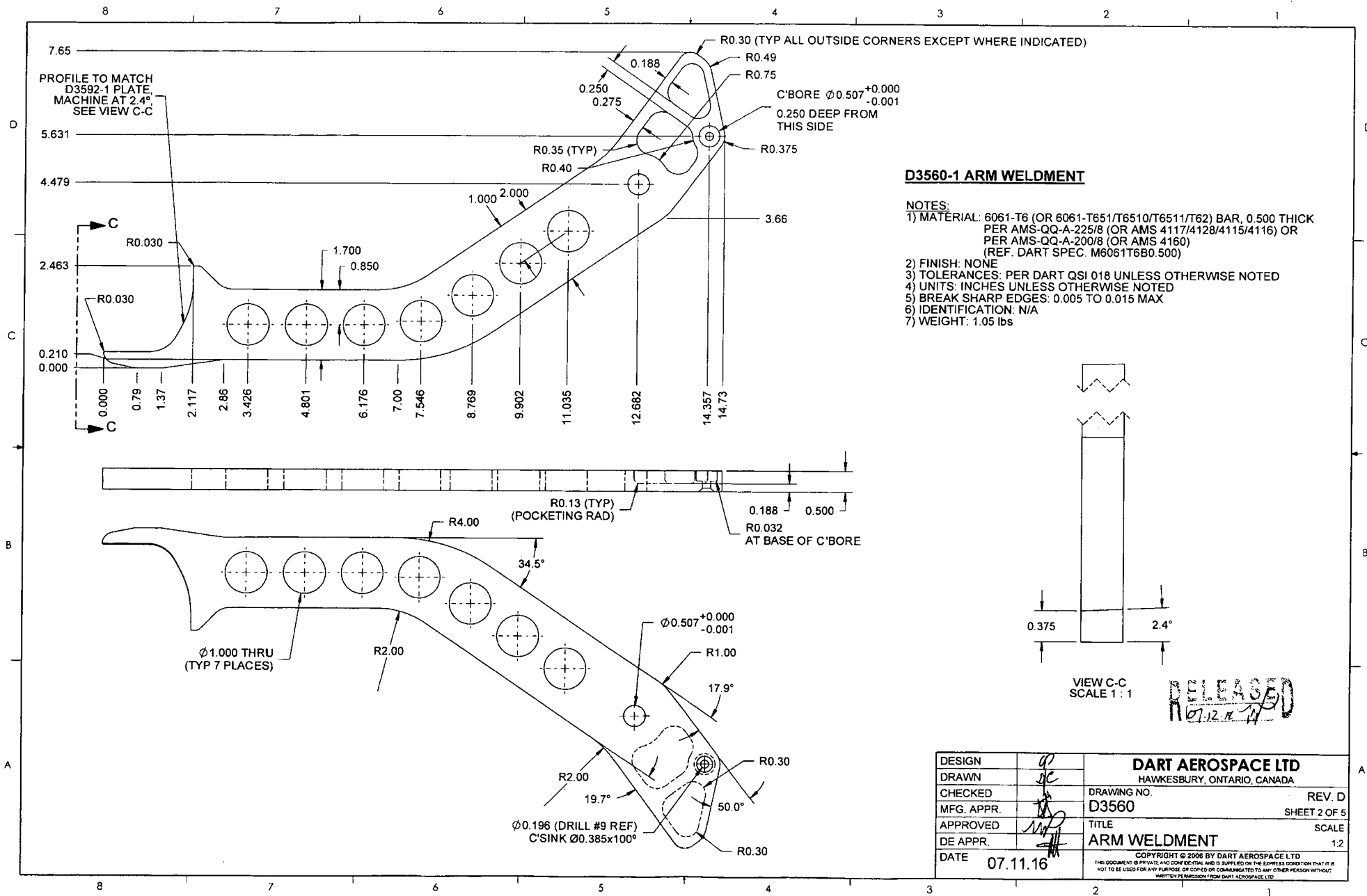
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8 7 6 5 4 3 2 1

RELEASED
07.12.16 WPD

D3560-2 ARM

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°,
SEE VIEW D-D

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.05 lbs

**VIEW D-D
SCALE 1:1**

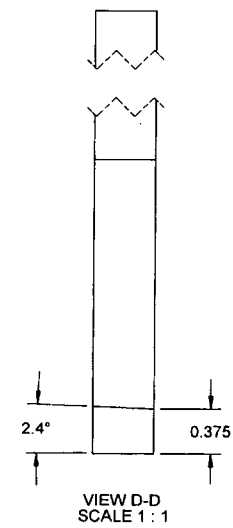
DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3560**
TITLE **ARM WELDMENT**
SCALE **1:2**
REV. D
SHEET 3 OF 5

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D3560-2 ARM

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PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



DESIGN	90	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3560	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARM WELDMENT	1:2
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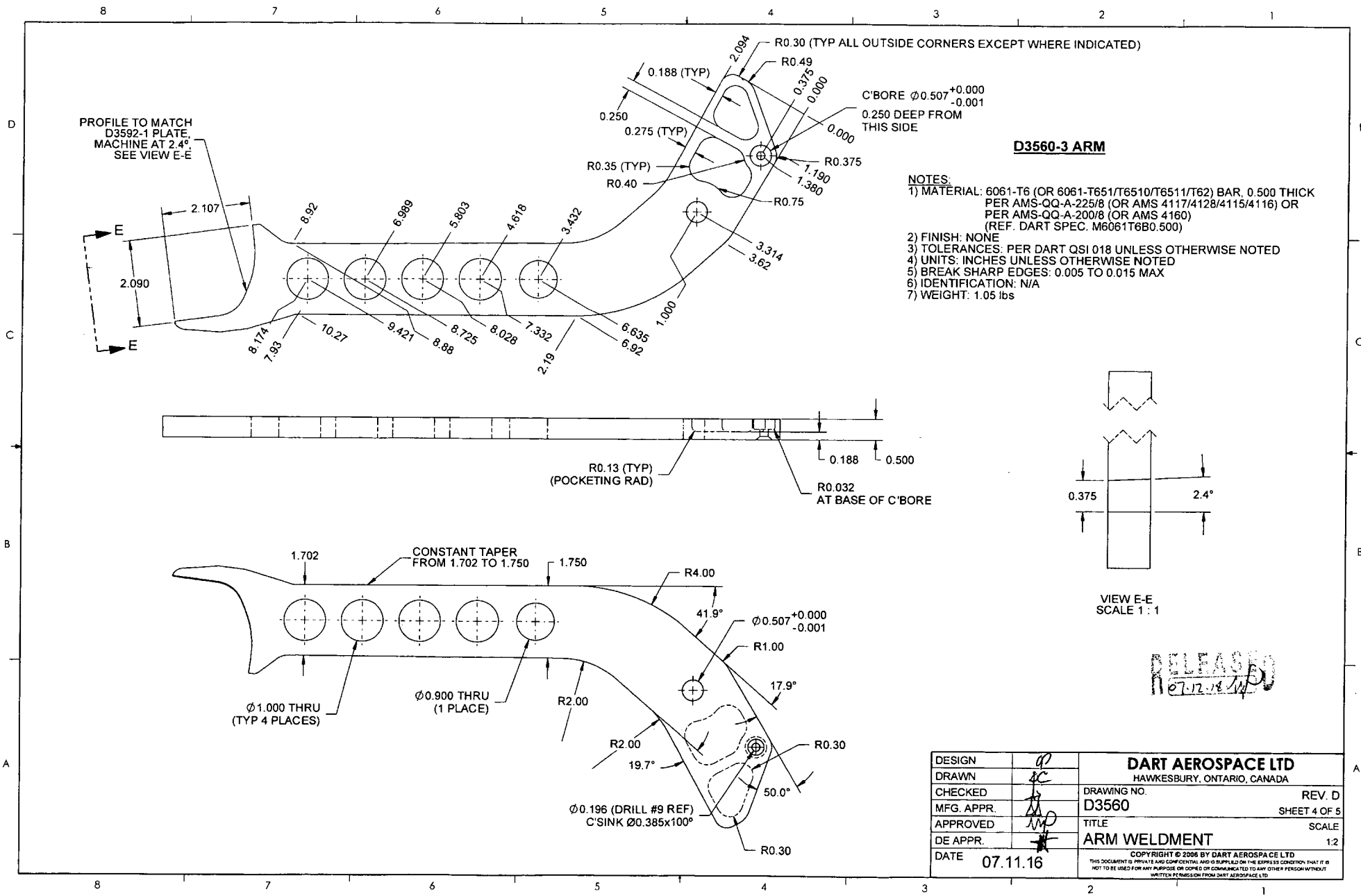
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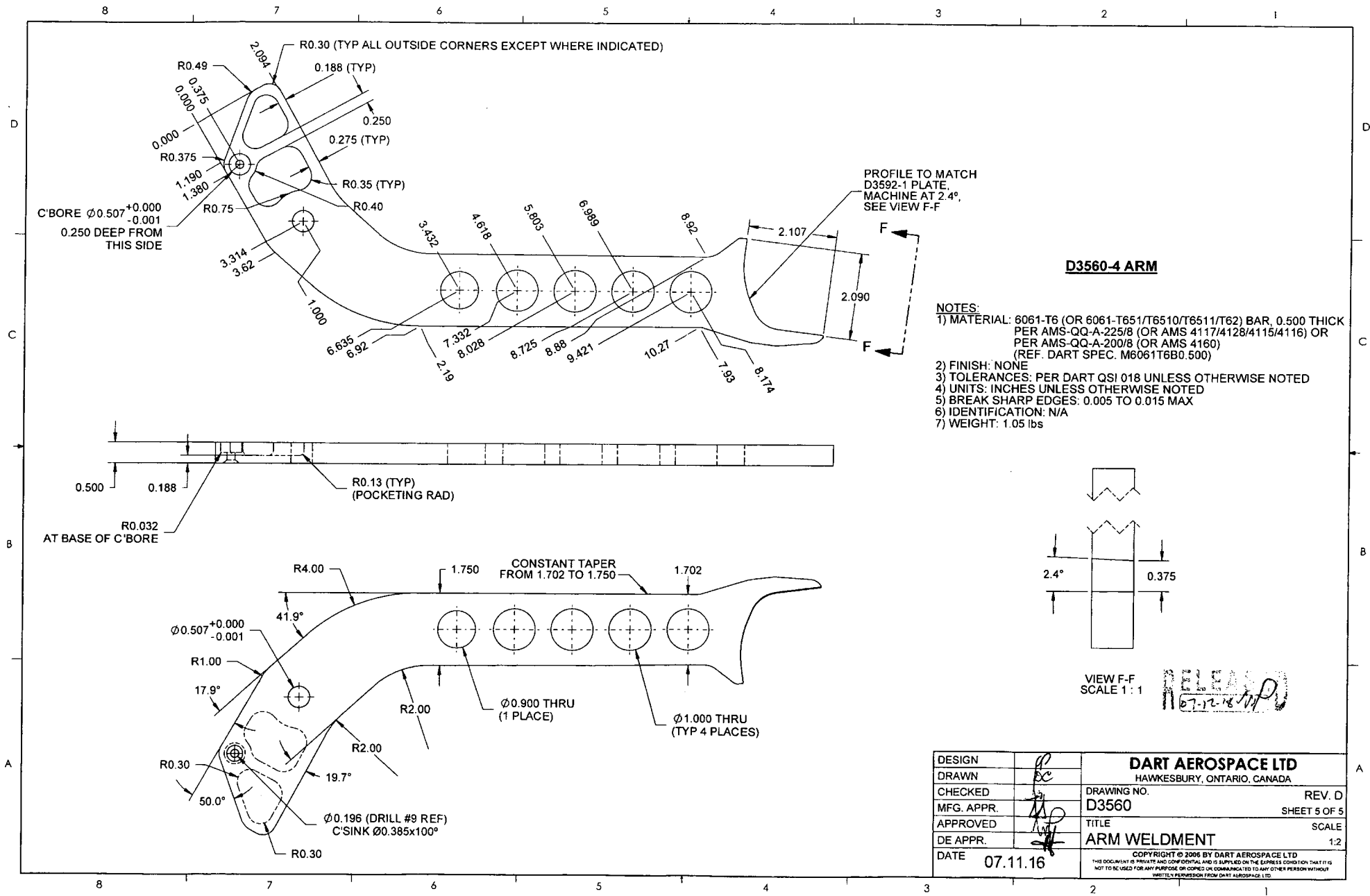
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DRAWN	EC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3560	REV. D
MFG. APPR.		TITLE ARM WELDMENT	SHEET 5 OF 5
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DART AEROSPACE LTD		Work Order:	
Description: Arm		Part Number:	D3560-2
Inspection Dwg: D3560 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5065	/			
Ø0.196	+0.005/-0.001	.196	/			
Ø1.000	+0.010/-0.001	1.003	/			
0.500	+/-0.010	.485	/			STK SIZE
0.250	+/-0.010	.244	/			
0.275	+/-0.010	.275	/			
0.188	+/-0.010	.183	/			
2.000	+/-0.010	2.000	/			
1.700	+/-0.010	1.700	/			
Ø0.385 x 100°	+/-0.010 x 0.5°	.385	/			
0.250 Deep	+/-0.010	.255	/			

Measured by: Rg	Audited by: SL	Prototype Approval:	N/A
Date: 12.1.11	Date: 12-01-11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-042	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	09.06.11	Dwg Rev updated	KJ	